

Work Order ID 58083

April 22, 2010 2:29:01 PM

Page 1

Item ID: D4050-5

Accept

Revision ID:

Item Name: Strut

Start Date: 4/22/10 Start Qty: 2.00

Required Date: 4/30/10 Req'd Qty: 2.00

Cust Item ID:

Customer:

Reference:

Approvals:

Process Plan:

Date: 10-4-22

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start

Stop

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D4050

B

100



Brake NC

Brake NC

NC BRAKE

0.00

Memo

0.00

Punch per Dwg. D4050 and Spec Control Dwg D2638

SB 10/04/28

(2)

110



Small Fab

Small Fab

Small Fab

0.00

Memo

0.00

Deburr

SB 10/04/28 (2)

120



QC

Quality Control

QC5- Inspect part completeness to step on W/O

0.00

Memo

0.00

SB 10/04/29

(2)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Page 2

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Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run

Start

Stop

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

130

White Gloss(Ref:4.3.5.2) per QSI005 4.3-Steel

0.00



Powdercoat

Memo

0.00

Powder Coating

START TIME: 7:15AM
OVEN TEMPERATURE: 400°F
FINISH TIME: 7:45AM

140

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

150

Identify as per dwg & Stock Location

0.00



Packaging

Memo

0.00

Packaging



⇒ J

10/05/03

2 4

②

10-5-3.

267

10-5-4 SP ②

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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NOTE: Date & initial all entries

Work Order ID 58083

April 22, 2010 2:29:01 PM

Page 3



Item ID:	D4050-5	Accept		Setup	Start	
Revision ID:						
Item Name:	Strut				Stop	
Start Date:	4/22/10	Start Qty: 2.00		Cust Item ID:		
Required Date:	4/30/10	Req'd Qty: 2.00		Customer:		
Reference:						

Approvals:	Process Plan:	Date:	Tooling:	Date:	Run	Start	
	QC:	Date:	SPC (Y/N):	Date:		Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160 	QC21- Final Inspection - Work Order Release	0.00							
QC	Memo	0.00							
Quality Control									

10/05/05 *[Signature]*
ME
10-5-4

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

April 22, 2010 2:29:00 PM

Page 1

Work Order ID: 58083

Parent Item: D4050-5

Parent Item Name: Strut

Comments: IPP RevA: new issue DD 10/01/05 verified by:EC IPP Rev:B as per
dwg revB DD 10.02.18 verified by:EC

Start Date: 4/22/10

Required Date: 4/30/10

Start Qty: 2.00

Required Qty: 2.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
M304TR0.750W.065		Purchased	No			100	f	78.0000	5.7912			



304 RD Tube .750 x .065W



Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

MAT017

78

114002

78

6 8B 04/28 (2)

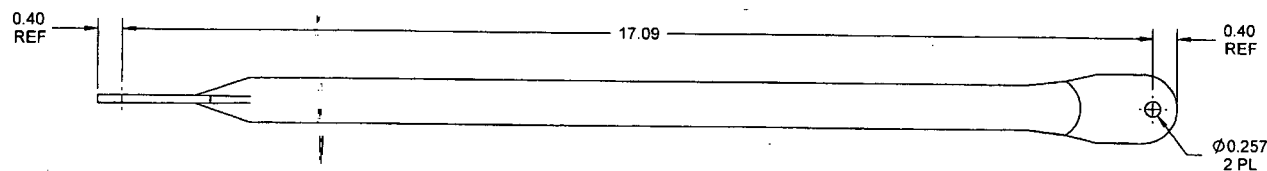
W/O:		WORK ORDER CHANGES					
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



8 D4050-1 STRUT

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 58083
2510-4-22

RELEASED
2010-02-16
NP

- NOTES:
- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SEAMLESS TUBE $\phi 0.750 \times 0.065$ WALL
REF DART SPEC M304TR0.750W.065
 - 2) FINISH: POWDER COAT "WHITE" (4.3.5.2) PER DART QSI 005.4.3
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: IDENTIFY WITH DART P/N USING FINE POINT PERMANENT INK MARKER
 - 7) WEIGHT: 0.67 lbs
 - 8) PUNCH BOTH END PER SPEC CONTROL DRAWING D2638

B	REVISE WALL THICKNESS FOR -17-31-51-8 0.065 WAS 0.048 (ZN A8-1, A8-2, A8-3, A8-4)	RF	10.02.02
A	NEW ISSUE	RF	10.01.28
REV.	DESCRIPTION	BY	DATE
DESIGN	RF		
DRAWN	RF		
CHECKED	<i>RF</i>		
MFG. APPR.	<i>RF</i>		
APPROVED	<i>RF</i>		
DE APPR.	<i>RF</i>		
DATE	10.02.02		

DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWING NO. D4050	REV. B SHEET 1 OF 4
TITLE STRUT	SCALE NTS

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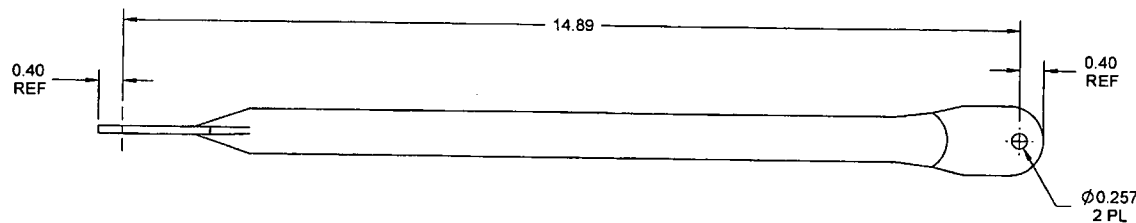
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



8 D4050-3 STRUT

w/o 58083

RELEASED
2010-02-16
JW

NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SEAMLESS TUBE $\phi 0.750 \times 0.065$ WALL
REF DART SPEC M304TR0.750W.065
- 2) FINISH: POWDER COAT "WHITE" (4.3.5.2) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 0.58 lbs
- 8) PUNCH BOTH END PER SPEC CONTROL DRAWING D2638

DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED	<i>[Signature]</i>	DRAWING NO. D4050	REV. B
MFG. APPR.	<i>[Signature]</i>	SHEET 2 OF 4	
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	STRUT	NTS
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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

0.40
REF

33.01

Ø0.257
2 PL

B D4050-5 STRUT

33810

w/o 58083

RELEASED
R 2010-02-16
JMP

NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SEAMLESS TUBE $\phi 0.750 \times 0.065$ WALL
REF DART SPEC M304TR0.750W.065
- 2) FINISH: POWDER COAT "WHITE" (4.3.5.2) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 1.04 lbs
- 8) PUNCH BOTH END PER SPEC CONTROL DRAWING D2638

DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED	RF	DRAWING NO. D4050	REV. B
MFG. APPR.	RF	TITLE STRUT	SHEET 3 OF 4
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DATE	10.02.02		

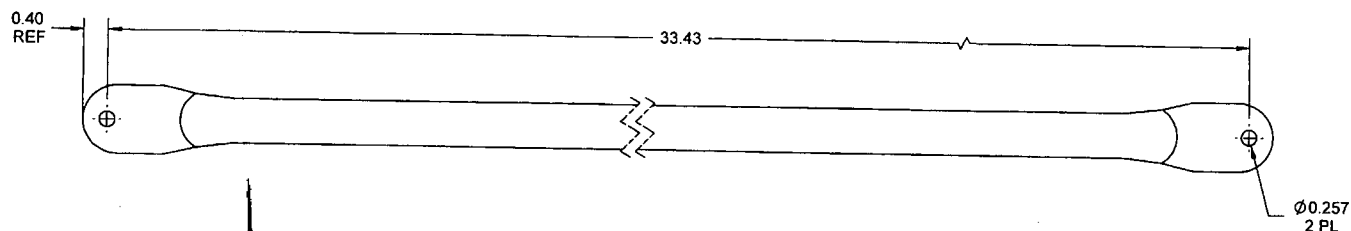
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8 D4050-8 STRUT

210 58083

RELEASED
2010-02-16

- NOTES:**
- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SEAMLESS TUBE $\phi 0.750 \times 0.065$ WALL
REF DART SPEC M304TR0.750V.065
 - 2) FINISH: POWDER COAT "WHITE" (4.3.5.2) PER DART QSI 005 4.3
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: IDENTIFY WITH DART P/N USING FINE POINT PERMANENT INK MARKER
 - 7) WEIGHT: 1.06 lbs
 - 8) PUNCH BOTH END PER SPEC CONTROL DRAWING D2638

DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED	RF	DRAWING NO.	REV. B
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